

Work Order ID 60475

Monday, July 12, 2010 1:18:10 PM



Page 1

Item ID: D4035-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/12/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-7-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4035

A

100

Weld per dwg A/R S.S. rod Batch: 0.00



Large Fab

Memo

0.00

- 1- Cut D4035-3 as per dwg D4035
- 2- Drill holes using DT9563 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

3AD 10-07-

② Pl 10-07-21

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

② PD 10-07-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60475

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Page 2

Item ID: D4035-043

Revision ID:

Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/12/2010 Start Qty: 2.00

Required Date: 7/16/2010 Req'd Qty: 2.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/07/22

(+2)

Memo

0.00

130



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

SAD

0.00

10-07-22

(2)

Memo

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/07/23

ME 10-7-22

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Picklist Print

Monday, July 12, 2010 1:18:15 PM

Page 1

Work Order ID: 60475

Parent Item: D4035-043

Parent Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 7/12/2010

Required Date: 7/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA: new issue DD 09.11.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4021-9

Manufactured No

100

Each

10.0000

2

4

Bushing

Location

Loc Qty

Loc Code

WA

10

56094

2

59838

8

100

f

260.5234

1.75

3.684211

M304TS0.750W.049

Purchased

No

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT

44.73396794

0

113763

23.9557189

114323

14.34201

114677

6.436239

114835

MAT017

3.68448E-05

114298

3.6845E-05

WA

215.7894

114992

215.7894

Spd 10.07.21

4

SAD 10-07-14

3.6842

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

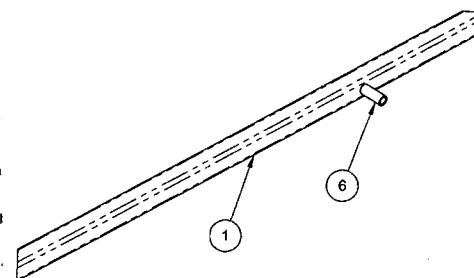
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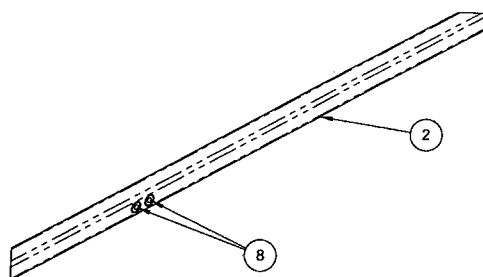
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

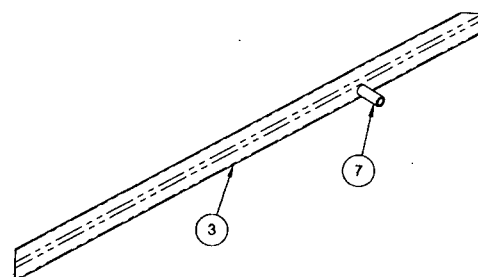


D4035-041 BASKET LID RIB ASSY, FWD

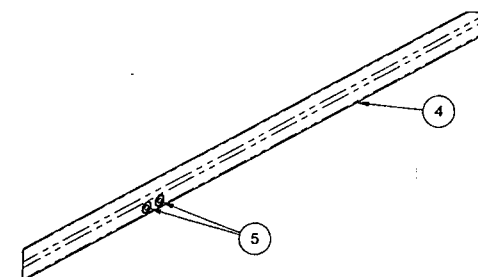
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60475
BS10-7-12



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
R 2010-03-12
AW

REV.	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS		BY	DATE
DRAWN	JPH	DART AEROSPACE LTD		
CHECKED		HAWKESBURY, ONTARIO, CANADA		
MFG. APPR.		DRAWING NO. D4035	REV. A	
APPROVED		TITLE BASKET LID RIB ASSY	SHEET 1 OF 5	
DE APPR.		SCALE NTS		
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

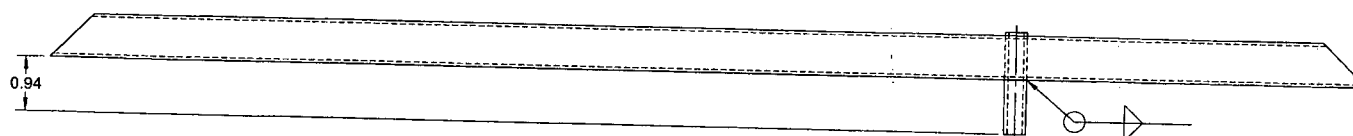
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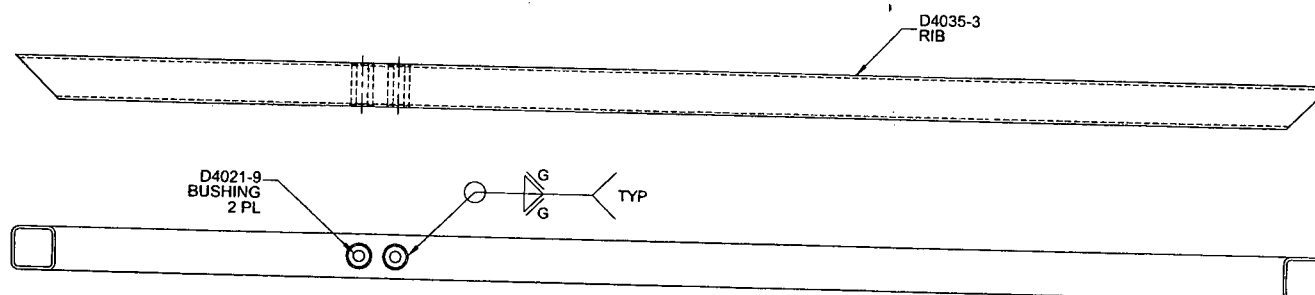
NOTE: Date & initial all entries



D4035-1
RIB

D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD



D4021-9
BUSHING
2 PL





D4035-3
RIB

TYP

D4035-043 BASKET LID RIB ASSY, AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
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2010-03-12

W/O 60475

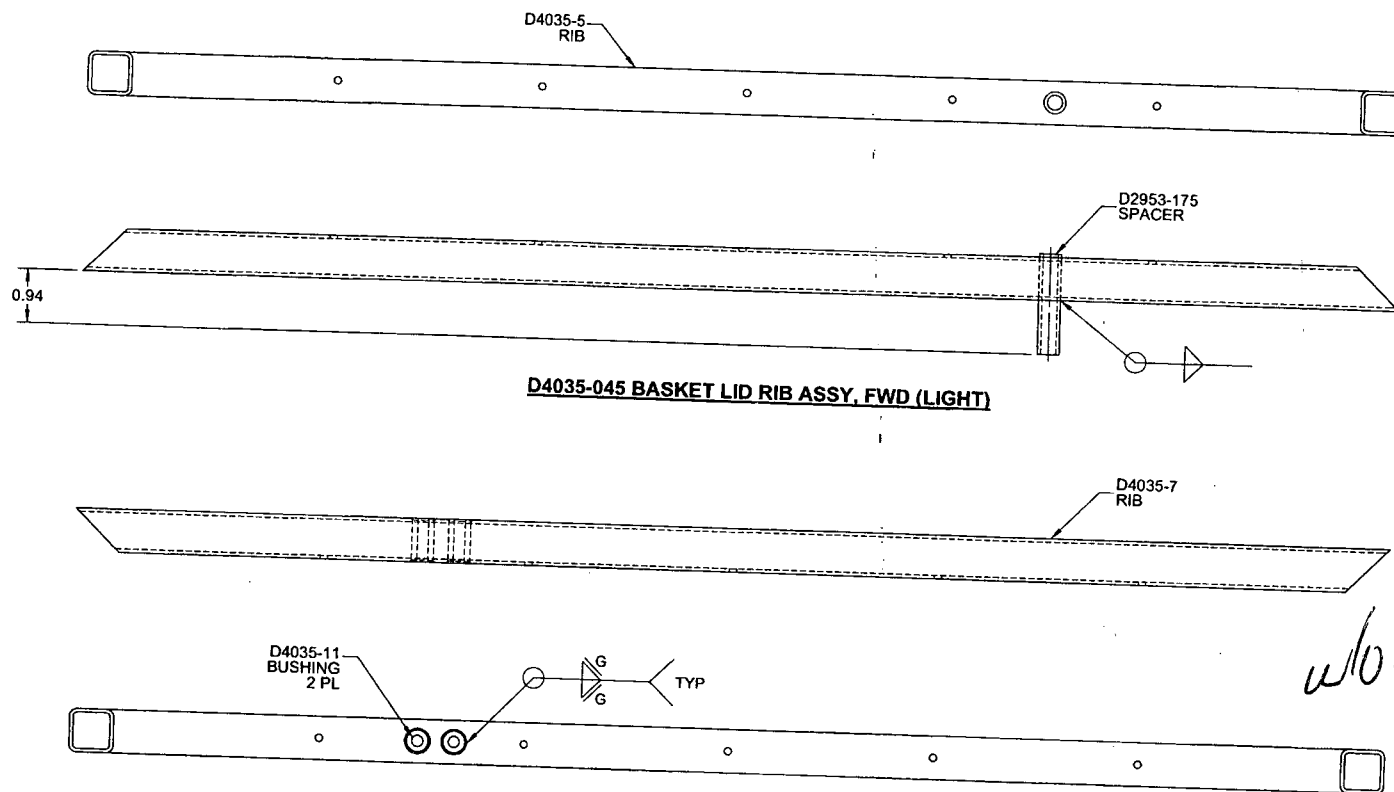
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4035	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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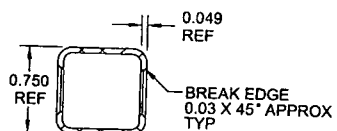
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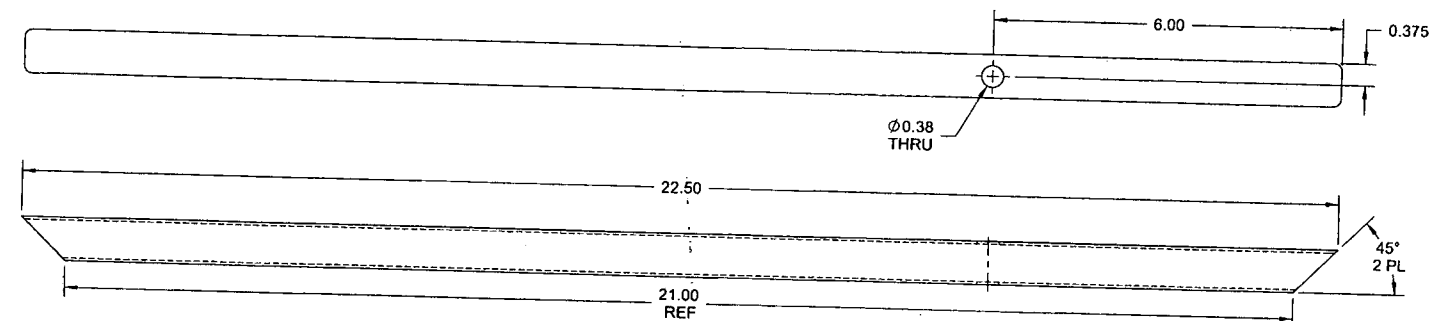
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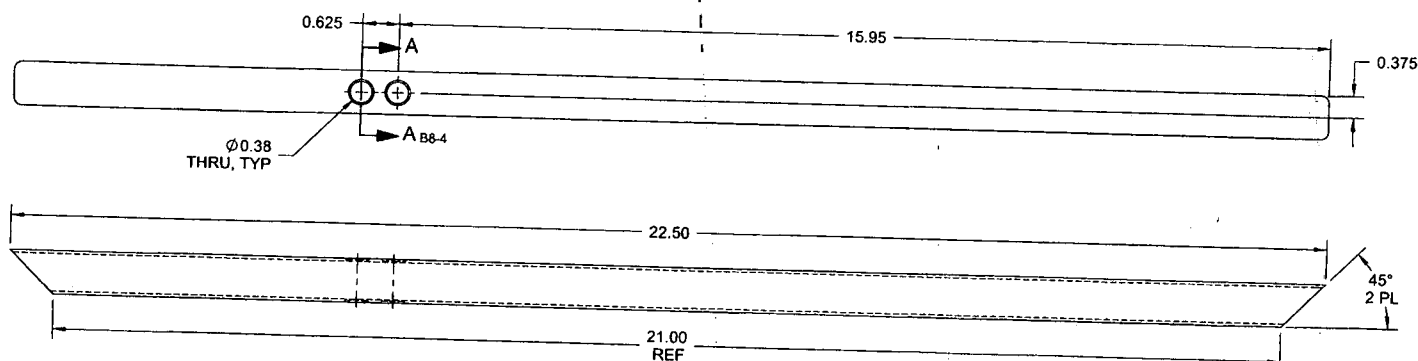
SECTION A-A B5-4

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
PER ASTM A554/A269 MILL FINISH
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.80 lbs



D4035-1 RIB



D4035-3 RIB

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
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MFG. APPR.		D4035	SHEET 4 OF 5
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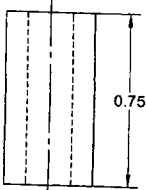
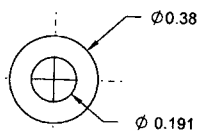
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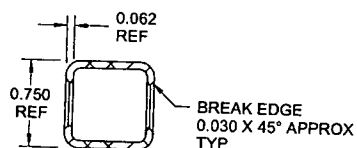
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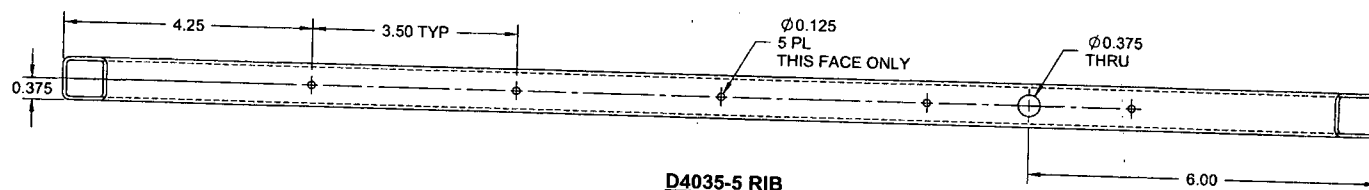
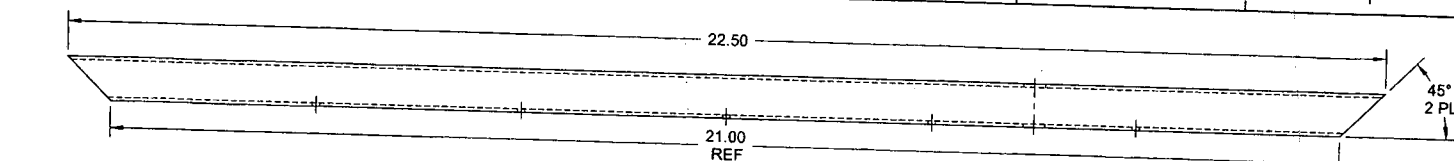
NOTE: Date & initial all entries



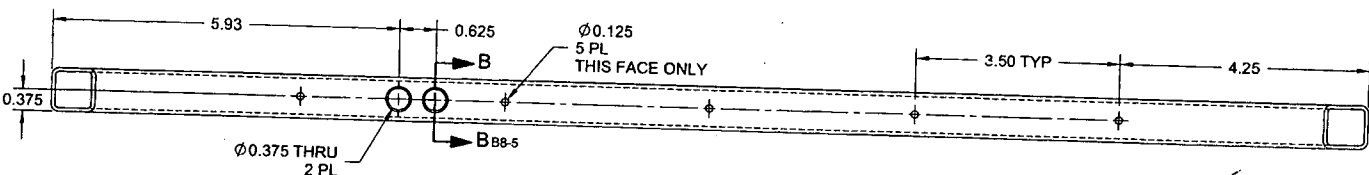
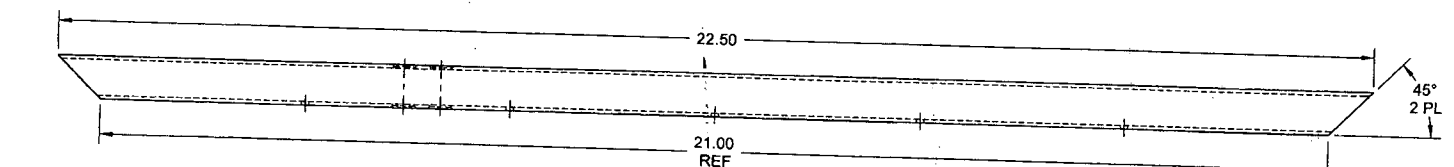
D4035-11 BUSHING



SECTION B-B B5-5






D4035-5 RIB



D4035-7 RIB

NOTES:

- 1) MATERIAL: -5 & -7: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6TS0.750W.062
-11: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -5 & -7: 0.33 lbs; -11: 0.01 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 5 OF 5
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